



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEA62309
Job Sheet 173837



004633

Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/7/18

Job Tracking No:

Due Date: 7/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	7/4/18	7/4/18	0.00	0.00	Start Up Small Fab-4	N/A	
110	Small Fab	1 pcs	7/4/18	7/4/18	0.00	1.00	Small Fab-9		MLL
120	QC	1 pcs	7/4/18	7/4/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-2		JRB 9-89
140	QC21-FG	1 Ea	7/4/18	7/4/18	0.00	0.00	QC21		21 JUL 25 2018

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses
110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	 DISPOSITION DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K84 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Part: RBZAG2809 Job No: 173887 Serial No/Batch: S089226 Revision: 12 Inspector: Exp Date: Instructions: Date: 07/05/18	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Forming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 80%;">QTY Effective :</td> <td style="width: 20%;">MRB (QSI042) Approval</td> </tr> <tr> <td style="height: 100px; vertical-align: middle; text-align: center;">Disposition</td> <td style="vertical-align: top;"> Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Forming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		QTY Effective :	MRB (QSI042) Approval	Disposition	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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Disposition	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																									

FAULT CATEGORY			
Temperature/Cure ☐ Setup ☐ M/Route ☐ Broken/Damage/Defect ☐ Section Incomplete/Unqualified ☐ Contamination ☐ Undersink ☐ Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	

Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Wave / Twist in Pass ☐ Marks/Chatter ☐ OTHER : _____
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31 ²⁶	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	100-Small Fab	5054248
5274T761 ⁴⁹	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	100-Small Fab	5083897
7189K31 ⁴⁵	Cable Ties Black	9 Ea (9 ea)	100-Small Fab	5038430
86625K31 ⁴⁵	Grommet Size 00	1 Ea (1 ea)	100-Small Fab	50384727
9052000 ³⁰	10" Mini Bungee Cord	4 Ea (4 ea)	100-Small Fab	5036095
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab	5066776
97526A421	Rivet	4 Ea (4 ea)	100-Small Fab	5038428
APP-1700-E ⁷¹	Hard Case	1 Ea (1 ea)	100-Small Fab	5057813
CL-194-TERM-2 ^{GA}	Eyelet	1 Ea (1 ea)	100-Small Fab	5041609
CL-2-C	Lanyard Wire	1.1600 ft (1.16 ea)	100-Small Fab	5026878
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	100-Small Fab	5054659
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab	501640
RBE-350DAMPER	Damper Spanner Wrench	1 Ea (1 ea)	100-Small Fab	5048091
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 Ea (1 ea)	100-Small Fab	5067376
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	100-Small Fab	5067612
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 Ea (1 ea)	100-Small Fab	5067475
RBE-350TEMP	Temperature Probe	1 Ea (1 ea)	100-Small Fab	Eugene 2891 33
RBE350A93-3200-20	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 Ea (1 ea)	100-Small Fab	5054629
RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench	1 Ea (1 ea)	100-Small Fab	5054629
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 Ea (1 ea)	100-Small Fab	Eugene
RBE350A93-3300-20	Tail Rotor Hub Socket	1 Ea (1 ea)	100-Small Fab	5076092
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 Ea (1 ea)	100-Small Fab	5089316
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 Ea (1 ea)	100-Small Fab	5082272
RBE350A93-3305-20	Tail Gearbox Wrench	1 Ea (1 ea)	100-Small Fab	5089426
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 Ea (1 ea)	100-Small Fab	5091170
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 Ea (1 ea)	100-Small Fab	5089196
RBE350A93-3316-20	Rotating Star Replacement Wrench	1 Ea (1 ea)	100-Small Fab	Eugene 285 32
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 Ea (1 ea)	100-Small Fab	5045036
RBE350A93-3400-00	Drive Shaft Thimble FG 106	1 Ea (1 ea)	100-Small Fab	5090950
RBE350A93-3500-00	Bearing Extractor	1 Ea (1 ea)	100-Small Fab	5083607
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 Ea (1 ea)	100-Small Fab	5045019
RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	100-Small Fab	5050007
RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	100-Small Fab	
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	100-Small Fab	5090971
RBE350A94-3301-00	T/R Accelerator Support	1 Ea (1 ea)	100-Small Fab	5077419
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 Ea (1 ea)	100-Small Fab	5058461
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	100-Small Fab	5082402
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	100-Small Fab	5054007
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 Ea (1 ea)	100-Small Fab	5078997
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 Ea (1 ea)	100-Small Fab	5092654
RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	1 Ea (1 ea)	100-Small Fab	5082386
RBE703A95-0508-00	Main Rotor Gear Box Drain Tube	1 Ea (1 ea)	100-Small Fab	5046436
RBE703A95-0520-01	Engine And Hydraulic Drain Tube	1 Ea (1 ea)	100-Small Fab	Eugene
RBE703A95-0520-01-11	Tube	1 (1 ea)	100-Small Fab	
RBE703A95-0520-01-13	Cap	1 (1 ea)	100-Small Fab	
RBE703A95-0520-01-15	Foam	1 (1 ea)	100-Small Fab	
RBEA62309-65	Laminated Location Card	1 Ea (1 ea)	100-Small Fab	5038322
RBEA62309-81	Top Shelf Cushion use in case APP-1700-E	1 Ea (1 ea)	100-Small Fab	5057814
RBEA62309-82	Top Cushion Stiffener use in case APP-1700-E	1 Ea (1 ea)	100-Small Fab	
RBEA62309-83	Bottom Shelf Cushion use in case APP-1700-E	1 Ea (1 ea)	100-Small Fab	5057826
RBEA62310	AS350/355 Engine Strut	1 Ea (1 ea)	100-Small Fab	Eugene -28558
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	100-Small Fab	5065446
RBW109-3101-58-1-1	Hammer, Steel	1 Ea (1 ea)	100-Small Fab	5058142
RBW109-3101-58-2-1	Hammer, Aluminum	1 Ea (1 ea)	100-Small Fab	5089084

AS REQUESTED BY PRODUCTION
MOL JULY 5/18

Job Allocations

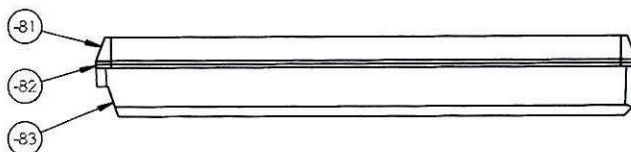
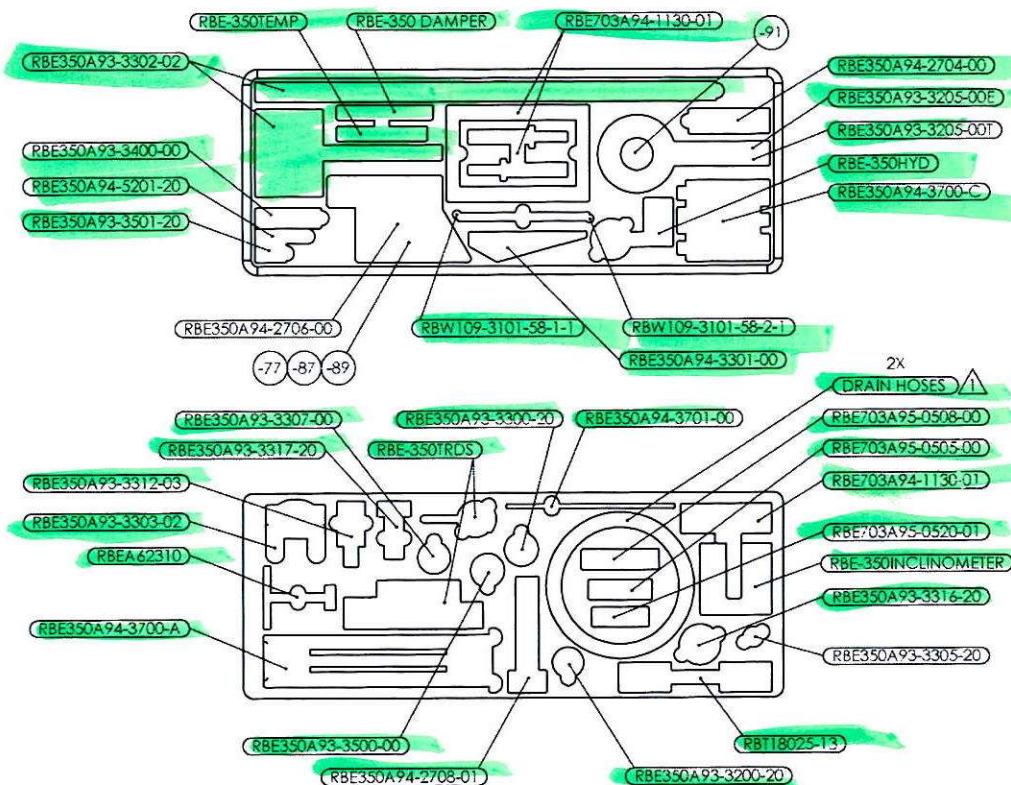
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	670	0
100-Small Fab	5274T761	1	30	0
	7189K31	9	1,000	0
	86625K31	1	50	0
	9052000	4	36	0
	97524A032	4	647	0
	97526A421	4	100	0
	APP-1700-E	1	17	0
	CL-.194-TERM-2	1	50	0
	CL-2-C	1	311	0
	NAS1756-12	1	367	0
	RB41011	1	842	0
	RBE-350DAMPER	1	1	0
	RBE-350HYD	1	10	0
	RBE-350INCLINOMETER	1	14	0
	RBE-350TDRS	1	9	0
	RBE-350TEMP	1	1	0
	RBE350A93-3200-20	1	1	0
	RBE350A93-3205-00E	1	8	0
	RBE350A93-3205-00T	1	9	0
	RBE350A93-3300-20	1	11	0
	RBE350A93-3302-02	1	0	0
	RBE350A93-3303-02	1	4	0
	RBE350A93-3305-20	1	0	0
	RBE350A93-3307-00	1	1	0
	RBE350A93-3312-03	1	2	0
	RBE350A93-3316-20	1	1	0
	RBE350A93-3317-20	1	1	0
	RBE350A93-3400-00	1	1	0
	RBE350A93-3500-00	1	2	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	10	0
	RBE350A94-2706-00	1	1	0
	RBE350A94-2708-01	1	1	0
	RBE350A94-3301-00	1	7	0
	RBE350A94-3700-A	1	2	0
	RBE350A94-3700-C	1	2	0
	RBE350A94-3701-00	1	29	0
	RBE350A94-5201-20	1	11	0
	RBE703A94-1130-01	1	1	0
	RBE703A95-0505-00	1	7	0
	RBE703A95-0508-00	1	3	0
	RBE703A95-0520-01	1	6	0
	RBEA62309-65	1	35	0
	RBEA62309-81	1	8	0
	RBEA62309-82	1	13	0
	RBEA62309-83	1	8	0
	RBEA62310	1	1	0
	RBT18025-13	1	17	0
	RBW109-3101-58-1-1	1	6	0
	RBW109-3101-58-2-1	1	6	0

Part Specifications

Specifications could not be found.

Plex 7/5/18 7:48 AM dart.lacelle.linda

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REV	FOR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-81 REARRANGED TOP SHELF PHOTO. -83 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -85 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED DAMPENER LOCATOR CARD AND LAMINAR COMPONENTS.	9/22/2009	WP	
2		REDRAWN TO USE HELIPRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES	1/25/2010	WP	RW
2A		ADDED NEW RED BARN PHOTO	2/11/2010	RJC	PW
3		-81 REARRANGED TOP SHELF TOOLS. -83 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TOPPRESS LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA94-3701-00. CHD CUTOUT DEPTH FOR RBEA94-3700-A. PREA94-5201-20 & RBEA93-3501-20. -85 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TOPPRESS LEVEL. CHD CARD INFORMATION FOR L.A.S.	2/18/2010	RJC	
4		-83 REARRANGED TOOL CUTOUTS. ADDED CUT OUT FOR RBEA62310. -85 UPDATED CARD.	3/9/2010	WP	
4A		-89 & -51 CHD QTY. FROM 3 TO 1 SET. UPDATED LAYOUT PHOTOS.	5/26/2010	RJC	
4B		-87 & -89 ADDED ONE TO EACH QTY	7/27/2010	WP	RW
4C		-91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-2 NUTS & BOLTS.	10/27/2010	WP	DW
5		-81 DELETED CUTOUT NOTCHES FOR RBEA93-3205-00-1	5/20/2011	RJC	PW
6		CORRECTED DRAIN HOSE 1/4" FROM RBEA93-3502-01 TO RBEA93-0520-01. -83 CHD FOAM CUTOUTS FOR RBEA93-3500-00, RBEA93-3300-20, RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -85 UPDATED CARD	2/27/2012	RJC	DW
7		-83 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUTS FOR INDIVIDUAL HOSES. CHD CUTOUT FOR RBEA94-3700-A FOR TIGHTER FIT. -85 UPDATED CARD	1/9/2013	RJC	SE
7A		-88 CORRECTED ITEM QTY FROM RBEA93-3305-00 TO RBEA93-3305-20. CHD FQTY. FROM 1 TO 1. ADDED A DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D, AND X1, X2, & X3 TO X.	4/11/2013	RJC	RJC
8		-81 CHD DIM WAS 4.75 B & 4.8. -83 CHD CUTOUT LOCATION FOR RBE350A94-3700-A. -85 CORRECTED 1/4" & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.	10/24/2013	RJC	DW
9		-81 CHD CUTOUT FOR RBE350HYD (NEW GAUGE). CHD CUTOUT FOR RBE350A94-3700-C TO FIT BETTER. -83 CHD CUTOUT FOR RBE350A94-3700-A TO SECURE TOOLS BETTER	3/25/2014	RJC	DW
10	15-0038	UPDATED TO NEW DRAWING STANDARD. -83 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -85 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER	2/11/2015	DPD	JAG
11	15-0149	-81 ADDED DETAIL SHEET, REPLACED RBEA93-3502-01 WITH RBE18025-13 AND MOVED TO -83. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 120 BLACK ETHAFOAM 220, BLACK. -83 ADDED DETAIL SHEET, CHD TOOL LAYOUT. CHD DIM WAS 4.75 B & 4.8. -85 DELETED DIM. 7.13 (2). 1.38 (1) & 7.75 (1) SPHERE. ADDED DIMS 7.1, 4.8 & 1.25. CHD FOAM WAS 120 BLACK ETHAFOAM 220, BLACK. MOVED RBE350A93-3500-00, RBE350A94-3701-00 & RBE350A93-3501-20 TO -81. -83 RBEA93-3501-20 REPLACED BY RBE18025-13. -85 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1, RBW109-3101-58-2, RBE18025-13, -87, -88, & -89.	9/20/2016	RJC	JAG
12	17-0013	-81 CHD DIM WAS 5.20 B, 4.2. -83 CHD DETAIL ORGANIZATION. REMOVED DIM 3.9 B & 1.38. 3.147, 2.434, 1.7, 2.25, 8.07, 7.13. ADDED DIM QTY 71, 30, 13, 5, 49, 12, 7, 13, 1, 38, 5, 8, 50, 7, 4, 63, 6, 4, 13, 8, 50. CHD DIM WAS 10.24 B, 7, 10.24, WAS 2X 34 B & 34, 58, WAS 12.33 B, 5.80, WAS 11.36 B, 11.57. -85 REARRANGED TOOLS ON BOTTOM SHELF, UPDATED ITEM #2 & 13 TOOL NUMBERS.	1/24/2017	DM	JAG

NOTE:

7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

DART AEROSPACE	
TITLE AS350-355 FIELD MAINTANANCE KIT	
DWG NO. RBEA62309	REV 12
MATERIAL FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS = 1/8" ANGLES 90° SURFACES = 125°	
1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL AS350/355	
SCALE 1:8	DATE 9/20/2016
SHEET 1 OF 8	